

Date: Tuesday, 02/06/2009 3:55:21 PM
 User: Julie Dawson

Process Sheet

| | |
|---|--|
| Customer : CU-DAR001 Dart Helicopters Services | Drawing Name : FRAME |
| Job Number : 48324 | |
| Estimate Number : 13820 | |
| P.O. Number : | Part Number : D22527 |
| This Issue : 02/06/2009 S.O. No. : | Drawing Number : D2252 REV G |
| Prsht Rev. : NC | Project Number : N/A |
| First Issue : / / Type : LARGE FAB ASSY | Drawing Revision : G |
| Previous Run : 47843 | Material : |
| Written By : | Due Date : 09/06/2009 Qty: 4 Um: Each |
| Checked & Approved By : <u>JUD 09-06-09</u> | |
| Comment : Est Rev:A 09.03.18 New Issue EC verified by:DD | |

Additional Product

Job Number:



| Seq. #: | Machine Or Operation: | Description : |
|---------|-----------------------|---------------|
|---------|-----------------------|---------------|

| | | |
|-----|----------------|---------------------------|
| 1.0 | M304TS0750W065 | 304 SQ Tube .75x.75x.065W |
|-----|----------------|---------------------------|



End Bar Scrap = 1.8 Sf



Comment: Qty.: 2.1000 f(s)/Unit Total: 8.4000 f(s)

304 SQ Tube .75x.75x.065W

batch: 111432 = 4.2 11148 = 4.2

SAD 09-06-09

(4)

| | | |
|-----|-------------|------------------------------|
| 2.0 | LARGE FAB 1 | LARGE FABRICATION RESOURCE 1 |
|-----|-------------|------------------------------|



Comment: LARGE FABRICATION RESOURCE 1

1- Cut as per dwg D2252

2- Deburr and remove identification markings on tube

SAD 09-06-09

(4)

| | | |
|-----|-----|------------------------------|
| 3.0 | QC5 | INSPECT WORK TO CURRENT STEP |
|-----|-----|------------------------------|



Comment: INSPECT WORK TO CURRENT STEP

SAD 09/06/09

(x4)

| | | |
|-----|-------------|-----------------------|
| 4.0 | PACKAGING 1 | PACKAGING RESOURCE #1 |
|-----|-------------|-----------------------|



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: Basket C/L

MF 09/06/09

(4x)

| | | |
|-----|------|------------------------------|
| 5.0 | QC21 | FINAL INSPECTION/W/O RELEASE |
|-----|------|------------------------------|



Comment: FINAL INSPECTION/W/O RELEASE

09/06/09

Job Completion



MF 09-06-09

| W/O: | | WORK ORDER CHANGES | | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|--|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector | |
| | | | | | | | | |
| | | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|--------------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

| ITEM | QTY -041 | QTY -043 | PART NUMBER | DESCRIPTION |
|------|-------------|-------------|-------------|------------------|
| 1 | X | | D2252-041 | BASKET ASSEMBLY |
| 3 | | X | D2252-043 | LID ASSEMBLY |
| 7 | 2 | 2 | D2221-1 | RIB |
| 8 | 5 | | D2235-1 | RIB |
| 9 | 2 | 2 | D2252-1 | FRAME |
| 10 | | 2 | D2252-7 | FRAME |
| 11 | 1 | | D2252-9 | FRAME |
| 12 | 1 | | D2252-11 | FRAME |
| 13 | 1 | | D2252-13 | FRAME |
| 14 | 1 | | D2252-15 | FRAME |
| 15 | 4 | | D2252-17 | FRAME |
| 16 | | 1 | D2252-23 | FRAME |
| 17 | 2 | | D2253-1 | LUG |
| 18 | 2 | | D2254 | GUSSET |
| 19 | 1 | 1 | D2327-3 | BUSHING |
| 20 | | 1 | D2329 | LABEL PLATE |
| 21 | 4 | 2 | D2581 | MOUNTING CHANNEL |
| 22 | | 2 | D2989-19 | RIB |
| 23 | 3 | | D3748-1 | HINGE HALF |
| 24 | | 3 | D3749-1 | HINGE HALF |

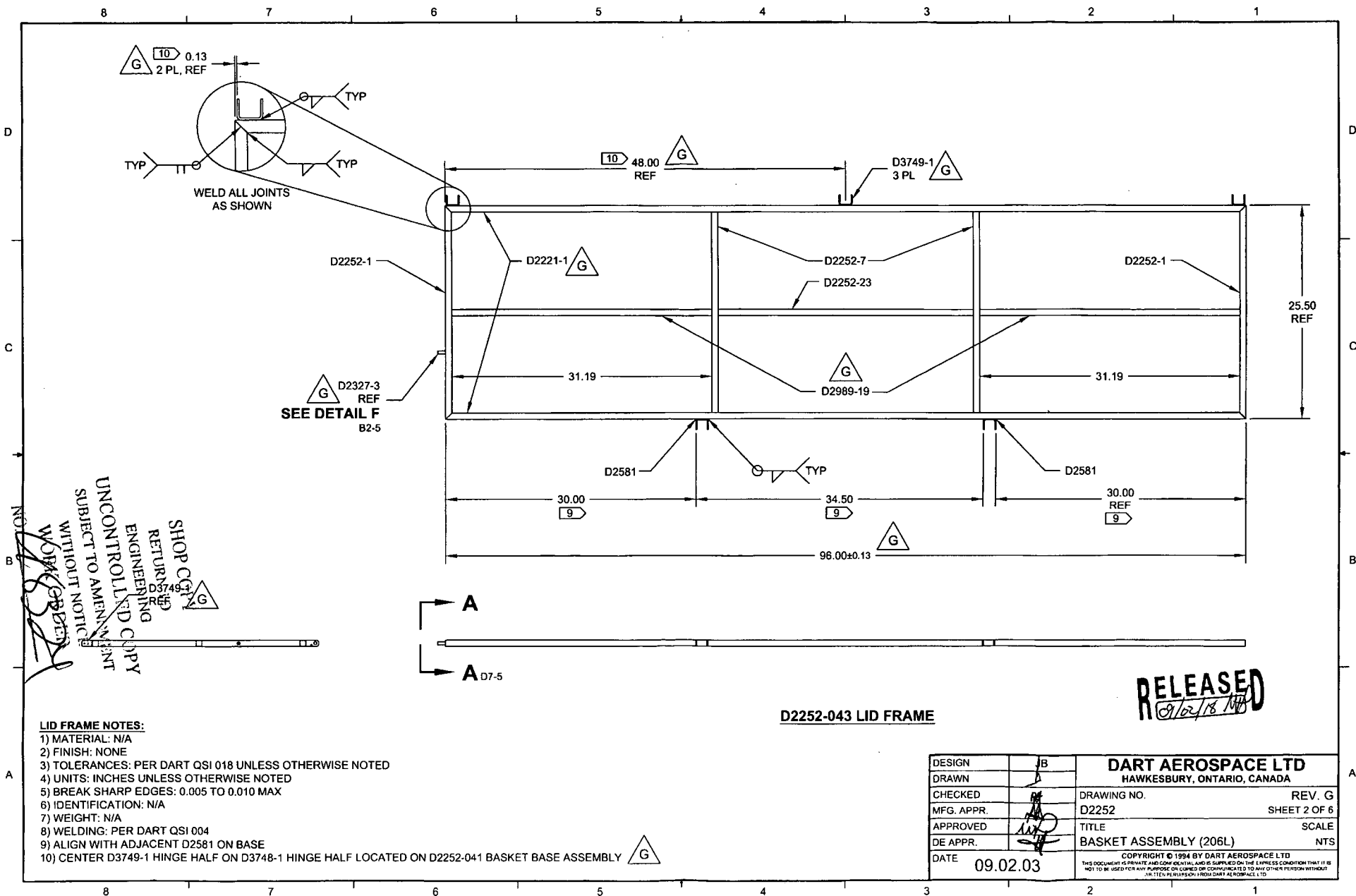
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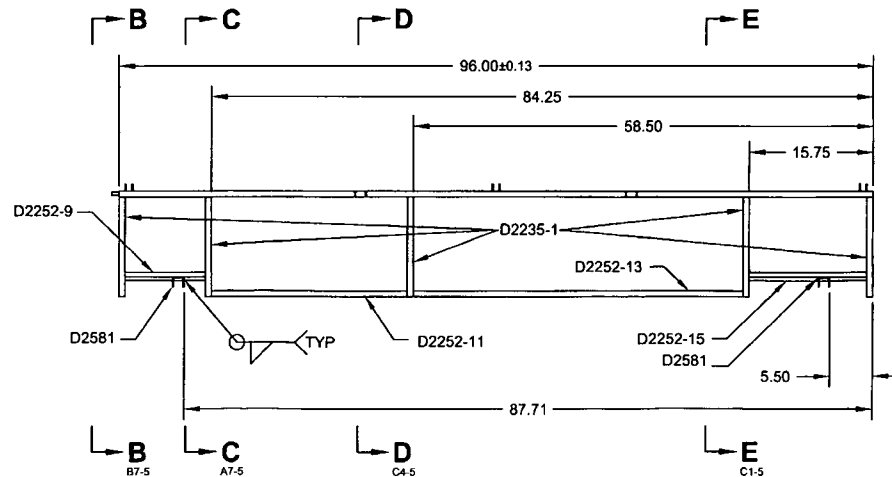
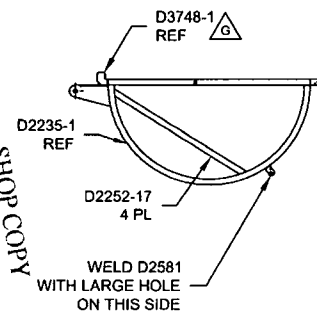
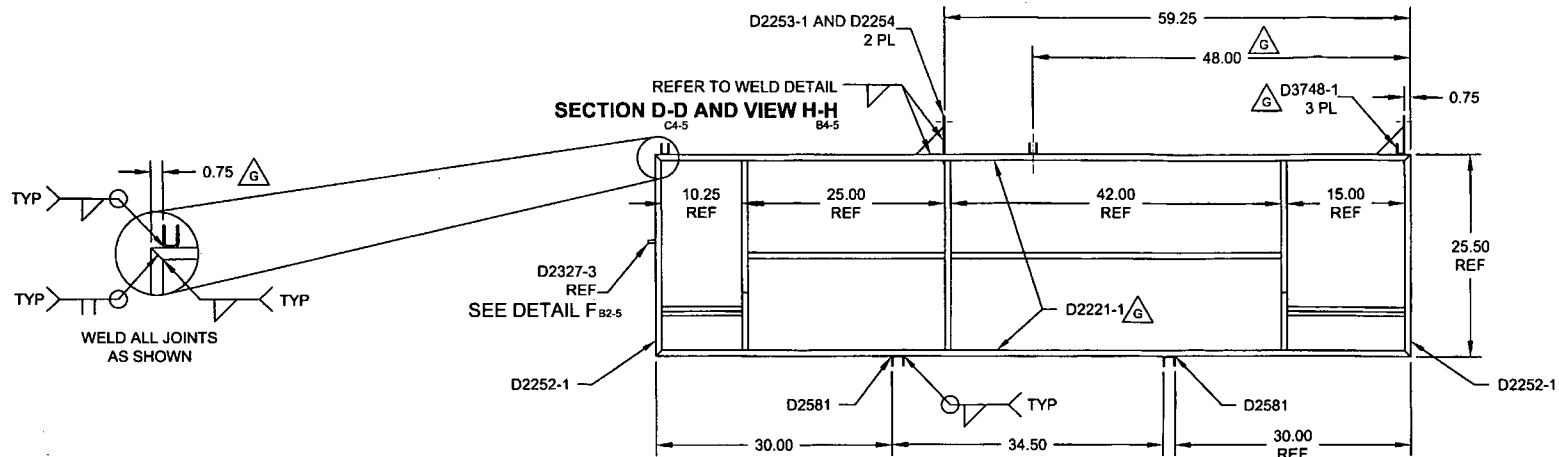
NOTES:

- 1) FRAME MATERIAL: AISI 304/316 SS, 3/4 x 3/4 x 0.065 WALL SQUARE TUBING
REF. DART SPEC M304TS0.750W.065
- 2) MESH MATERIAL: 3/4-16F EXPANDED SS
REF DART SPEC M304EX0.75-16F
- 3) FINISH: POWDER COAT ASSEMBLY GLOSS WHITE (4.3.5.2) PER DART QSI 005 4.3
- 4) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) BREAK SHARP EDGES: N/A
- 7) IDENTIFICATION: N/A
- 8) WEIGHT: N/A
- 9) WELDING: PER DART QSI 004

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| | | | |
|------------|---|--|--------------|
| G | ADDED 'ITEM' COLUMN TO PARTS LIST; ADDED NOTE 10 ON SHT 2; ITEMS 23 AND 24 REPLACE D2232-1/-3; STRETCHED LID FROM 95.27" TO 96.00"; ITEM 7 REPLACES D2252-3/-19; ITEM 19 (ON LID) REPLACES D2327-1; ITEM 22 REPLACES D2252-21; UPDATED TOOLING (ZN A6-5). P/N REASON: SEE PAR#09-006. | MB | 09.02.03 |
| F | DRAWING UPDATED TO CURRENT STANDARDS. SHT 6 ADDED. SHT 2 VIEWS INVERTED FOR CLARITY. FRAME MATERIAL THICKNESS WAS 0.060. | AJS | 08.08.11 |
| E | INCORPORATED D1 & D2. ADDED D2231-1/-3 & D2252-19. | MB | 05.11.10 |
| D | MODIFIED LATCH, D2581 WAS D2255-3 | BK | 99.09.14 |
| C | RE-DRAWN | BK | 95.12.11 |
| REV. | DESCRIPTION | BY | DATE |
| DESIGN | JJB | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| DRAWN | | DRAWING NO. | REV. G |
| CHECKED | | D2252 | SHEET 1 OF 6 |
| MFG. APPR. | | TITLE | SCALE |
| APPROVED | | BASKET ASSEMBLY (206L) | NTS |
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| DATE | 09.02.03 | | |





D2252-041 BASE FRAME ASSEMBLY

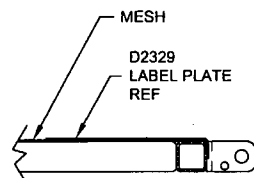
BASE FRAME NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: N/A
- 8) WELDING: PER DART QSI 004

| | | | |
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| MFG APPR. | | D2252 | SHEET 3 OF 6 |
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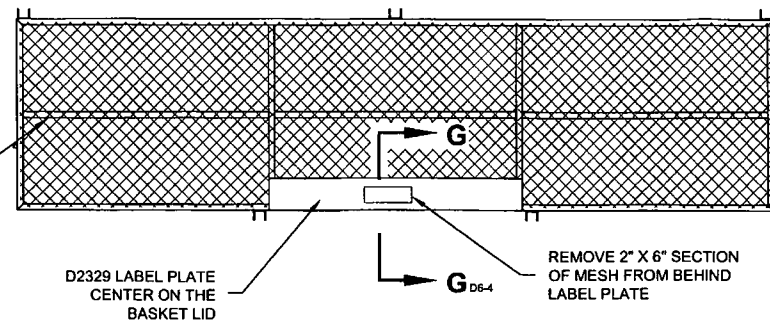
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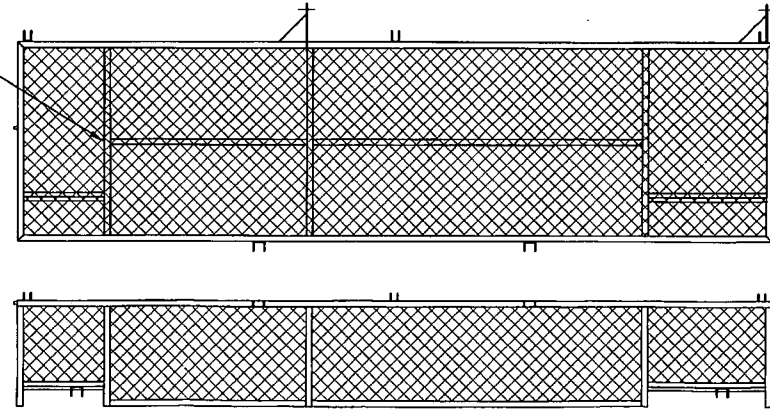


SECTION G-G C3-4
ROTATED 90° CCW

TACK WELD EACH
STRAND END OF
STEEL MESH TO FRAME



D2252-043 LID ASSEMBLY

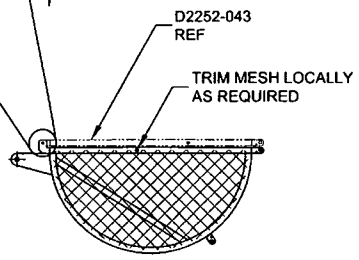


D2252-041 BASE ASSEMBLY



TRANSFER MARK FROM D3749-1
HINGE HALF ON D2252-043 LID ASSY,
DRILL Ø0.261 THRU

0.200
PRIOR TO DRILLING Ø0.261
HOLE THRU D3748-1 AND D3749-1



D2252-043
REF

TRIM MESH LOCALLY
AS REQUIRED

ASSEMBLY NOTES:

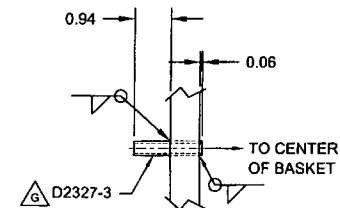
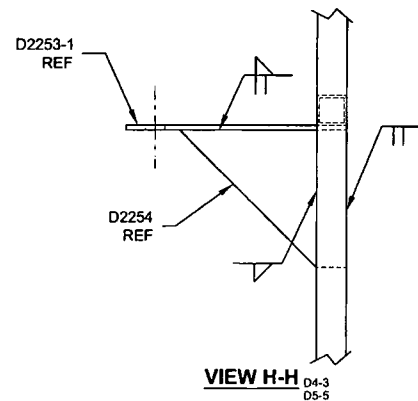
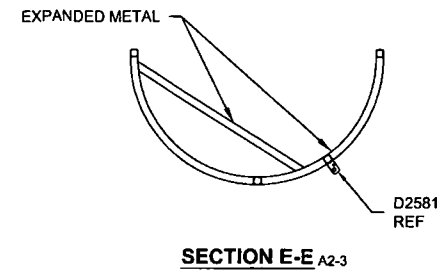
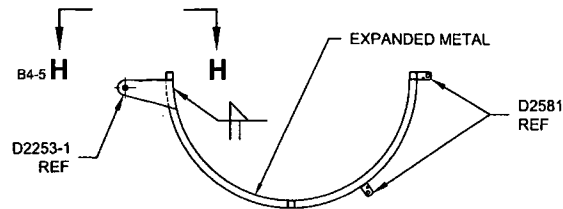
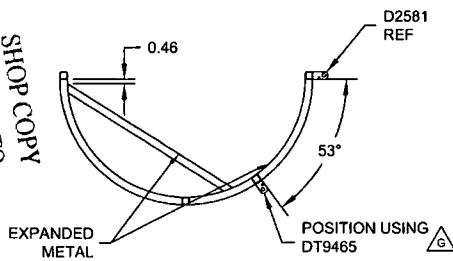
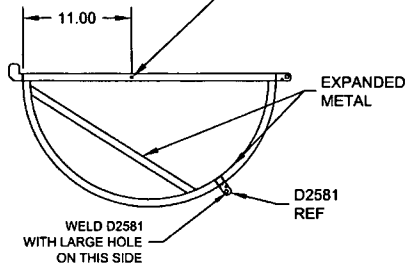
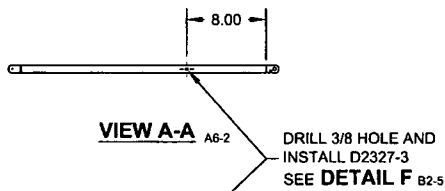
- 1) MATERIAL: SEE SHEET 1 FOR MESH MATERIAL
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: N/A
- 8) WELDING: PER DART QSI 004

| | | | |
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| DESIGN | JB | DART AEROSPACE LTD | |
| DRAWN | | HAWKESBURY, ONTARIO, CANADA | |
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SPACER INSTALLATION C6-2

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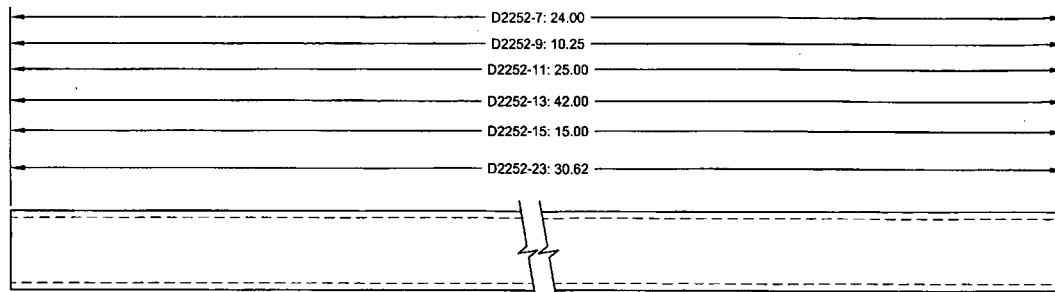
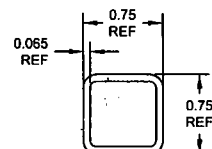
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8 7 6 5 4 3 2 1

D

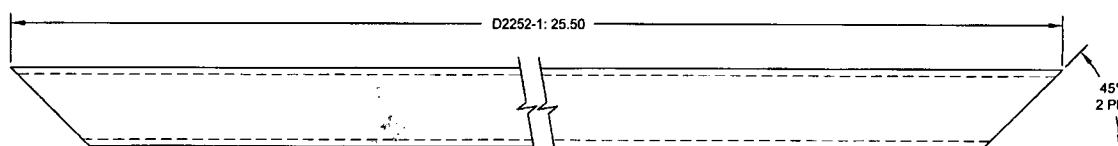
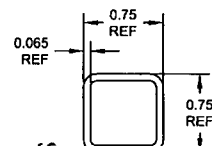
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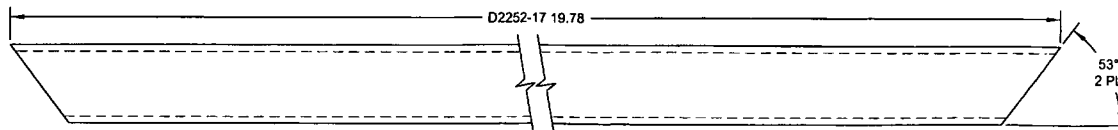
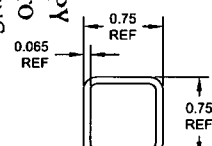
D2252-7 FRAME
D2252-9 FRAME
D2252-11 FRAME
D2252-13 FRAME
D2252-15 FRAME
D2252-23 FRAME

C

C



D2252-1 FRAME



D2252-17 FRAME

B

RELEASED
01/02/16/MB

A

A

- NOTES:**
 1) FRAME MATERIAL: SEE SHEET 1
 2) FINISH: NONE
 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 6) IDENTIFICATION: N/A
 7) WEIGHT: N/A

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